

Date: Monday, 3/13/2006 10:01:26 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RING
Job Number	: 26210B		
Estimate Number	: 10395		
P.O. Number	: N/A	Part Number	: D29685
This Issue	: 3/13/2006 S.O. No. : N/A	Drawing Number	: D2968 UNDER REVIEW OK 06-03-15
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/13/2006 Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 24537B	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 4/10/2006
Checked & Approved By	: SEE ABOVE USER & DATE	Qty:	81
Comment	: Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NT3000W500	4130 Tube 3"ODx.5"W
Comment: Qty.: 0.0218 f(s)/Unit Total : 0.8736 f(s) Material: AISI 4130 Ø 3/4 " Bar (M4130N-R0.750) Batch: M18948 MS 06/03/14 81 Identify AS D2968-1		
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
Comment: MORI SEIKI LATHE 1-Turn Blank as per Folio FA049 and Dwg D2968 MS 06/03/14 2-Deburr, no sharp edges 81		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE MS 06/03/14 81		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK BL 06.03.18 81		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WS KA 06/03/18 81		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/13/2006 10:01:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 26210B

Part Number: D29685

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



(81)

Comment: DOCUMENT CONTROL

Inspection Level 21



06/04/10

Job Completion



U 06.04.07

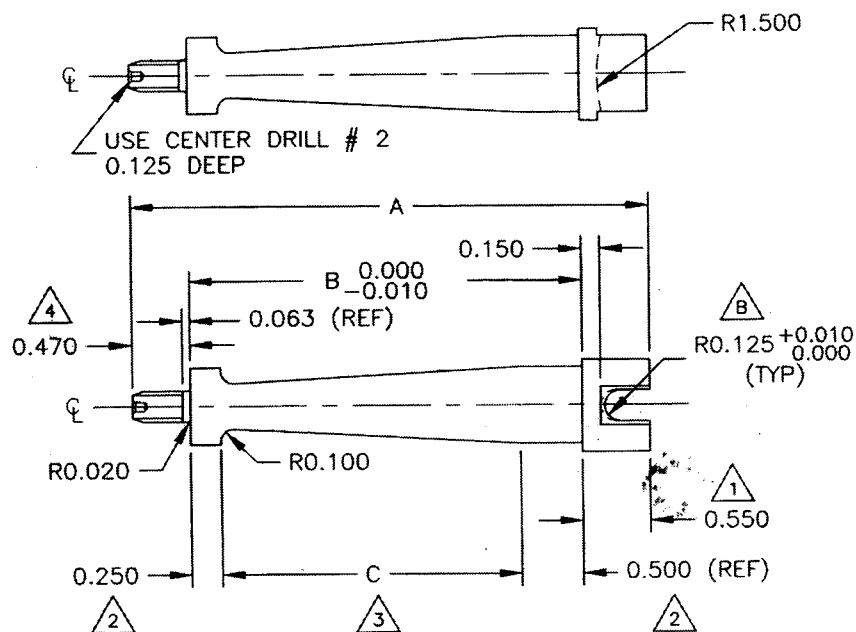
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ 0.750 O.D.

△ 0.625 O.D.

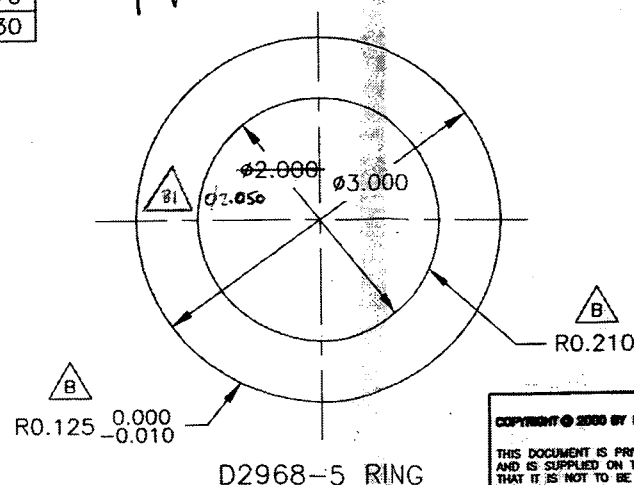
△ MACHINE UNIFORM TAPER FROM 0.363 O.D. TO 0.625 O.D.

△ 1/4-28 UNF THREAD WITH 0.063 GRIP
MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-5 RING

76210 A
-5 B
-1

D2968-5 RING

RELEASED

UNDER REVIEW

USE 2968-1 STEM
FOR -041
USE 2968-3 STEM
FOR -043

D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD.
CHECKED	APPROVED	DART AEROSPACE LTD.
DATE	00.05.31	D2968
		TOW RING

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04.01.06 2.05D W4S 2.000

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